

Work Order ID: 54146

December 1, 2009 12:46:33 PM



Page 1

Item ID: D206-667-203BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft, Blue

Start Date: 02/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 15/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *09/12-1*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| D206-667-243 | C |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

S 10/01/29

for BG 10/01/29

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

(IX) d MB 09-12-08

120

0.00



QC15- Crosstube Dimensional Check

QC

Memo

0.00

Quality Control

(X) P 09.12.04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 | | 0.00 | | | | | | | |
| | Crosstubes | | | | | | | | |
| Crosstubes | Memo | 0.00 | | | | | | | |
| Crosstubes | 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes. | | | | | | | | |
| | 2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 Check dimensions between holes on all four sides. | | | | | | | | |
| | 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. | | | | | | | | |
| | 4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes. | | | | | | | | |
| | 5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 | | | | | | | | |
| | 6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes. | | | | | | | | |
| | 7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243. | | | | | | | | |
| | 8-C'sink holes as per Dwg D206-667-243. | | | | | | | | |
| | 9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243 Inside of Cuff (Do not engrave on outside of tube) | | | | | | | | |
| | 10 -Deburr & Inspect for surface damage. Repair damage within limits as per Dwg | | | | | | | | |

MB
09-12-10MB
09-12-10

| W/O: | | WORK ORDER CHANGES | | | | | |
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

D206-667-243

140

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

1 - - AUG-12-14

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

27 809/12/14



160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 809/12/14



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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

170

Outsource process - NDT per QSI038 4.1

0.00



Outsource2

Memo

0.00

Outsource process - NDT

Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: 10943
LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

CZ 09/12/14 ①

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

09/12/14 ①

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Ensure results are as per Dwg D206-667-243

09 12 15 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
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Revision ID:

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Start Date: 02/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 15/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

195

0.00



SprayPaint

Memo

0.00

Spray Painting

prime grey B 110918
spray paint delfleet blue B 113121
clear delfleet B 113314

ml 10 / 01 / 27 ①

210

0.00



QC

QC14- Inspect Spray Paint

Memo

0.00

Quality Control

Wrap in plastic bag to protect from scratches

1 10 01 29

220

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Install nut plates as per Dwg D206-667-243.

ml 10 01 15 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
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Cust Item ID:

Required Date: 15/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

230

0.00



Skidtubes

m

10

01

28

Skidtubes

Memo

0.00

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note (3) top holes should be facing up.
A/R Magnobond 6398: 112417

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

m 10/01/29

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1

10-01-29

| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID 54146

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Cust Item ID:

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-1-29

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/1/29

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-203
Location: _____
PPP Rev: _____

Rev D

10-1-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Work Order ID 54146

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/01/29

u 40.01 29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54146

Parent Item: D206-667-203BL

Parent Item Name: Crosstube Aft, Blue

Comments:

Start Date: 02/12/2009

Required Date: 15/12/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

| | | | | | | | | | | | | |
|---------|--|-----------|----|--|--|--|------|----------|---------|--|--|--|
| AN5-10A | | Purchased | No | | | | Each | 152.0000 | 10.0000 | | | |
|---------|--|-----------|----|--|--|--|------|----------|---------|--|--|--|



Bolt

M113524 10-1-29 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | | |
|--------|-----|--|
| ST | 152 | |
| 107013 | 8 | |
| 110363 | 2 | |
| 112314 | 1 | |
| 112385 | 8 | |
| 112933 | 50 | |
| 113149 | 50 | |
| 113255 | 33 | |

| | | | | | | | | | | | | |
|---------|--|-----------|----|--|--|--|------|----------|--------|--|--|--|
| AN5-32A | | Purchased | No | | | | Each | 187.0000 | 4.0000 | | | |
|---------|--|-----------|----|--|--|--|------|----------|--------|--|--|--|



Bolt

10-1-29 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | | |
|--------|-----|--|
| ST | 187 | |
| 106242 | 3 | |
| 106519 | 4 | |
| 110363 | 17 | |
| 112805 | 13 | |
| 112933 | 50 | |
| 113121 | 100 | |

2
2

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Picklist Print

December 1, 2009 12:42:23 PM

Work Order ID: 54146

Parent Item: D206-667-203BL

Parent Item Name: Crosstube Aft, Blue


Start Date: 02/12/2009

Required Date: 15/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| S AN5-34A  Bolt | | Purchased | No | | | | Each | 158.0000 | 4.0000 | | 10-1-29 | SP |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 158 | |
| 104679 | 2 | |
| 105408 | 1 | |
| 107013 | 2 | |
| 111425 | 3 | |
| 113149 | 100 | 4 |
| 113226 | 50 | |

AN960JD516

Purchased

No

Each

1,084.000 18.0000

Washer

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 1084 | |
| 110363 | 46 | |
| 110523 | 57 | |
| 111279 | 39 | |
| 112082 | 64 | |
| 112314 | 14 | |
| 112828 | 364 | |
| 113149 | 500 | |

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Parent Item Name: Crosstube Aft, Blue

Start Date: 02/12/2009

Required Date: 15/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

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|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D206-667- 203TRNRevC | | Manufactured | No | | | | Each | 4.0000 | 1.0000 | | | |



Crosstube Turning Detail



B-541164 mb 09-12-07

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| FG | 4 | |
| 53414 | 1 | |
| 53415 | 1 | |
| 53649 | 1 | |
| 53651 | 1 | |

D2873-043RevA

Manufactured No



Nut Plate Assembly



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 33 | |
| 45370 | 2 | |
| 45422 | 1 | |
| 50002 | 10 | |
| 50871 | 20 | |

mb 10/01/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

December 1, 2009 12:42:23 PM

Work Order ID: 54146



Parent Item: D206-667-203BL



Parent Item Name: Crosstube Aft, Blue

Start Date: 02/12/2009

Required Date: 15/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2873-045RevA | | Manufactured | No | | | | Each | 31.0000 | 2.0000 | | | |
| | | | | | | | | | | | | |

Nut Plate Assembly

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 31 | |
| 45210 | 3 | |
| <u>50001</u> | 28 | |

mm 10/01/15

D2892-1RevA

Manufactured No

Each 57.0000 2.0000



Support

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 57 | |
| 41986 | 12 | |
| 42785 | 20 | |
| 53124 | 13 | |
| <u>53348</u> | 12 | |

mm 10/01/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

December 1, 2009 12:42:23 PM

Work Order ID: 54146



Parent Item: D206-667-203BL



Parent Item Name: Crosstube Aft, Blue

Start Date: 02/12/2009

Required Date: 15/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3595-063-450RevA | | Manufactured | No | | | | Each | 196.9689 | 4.0000 | | | |
| | | | | | | | | | | | | |
| RUBBER CUSHION | | | | | | | | | | | | |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| LG | 92 | |
| 52447 | 92 | |
| Main Warehouse | | |
| ST | 104.9689 | |
| 38959 | 2 | |
| 43210 | 2.59 | |
| 46465 | 0.3789 | |
| 53775 | 100 | |

ml 10/01/28

MS20601-AD4W10

Purchased

No

Each

201.0000

14.0000



RIVET

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 201 | |
| 110665 | 58 | |
| 111177 | 43 | |
| 113220 | 100 | |

ml 10/01/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 6

December 1, 2009 12:42:24 PM

Work Order ID: 54146

Parent Item: D206-667-203BL

Parent Item Name: Crosstube Aft, Blue

Start Date: 02/12/2009

Required Date: 15/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS21042L5 Nut | | Purchased | No | | | | Each | 758.0000 | 4.0000 | | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

758

110382

10

111127

4

111636

11

112314

733

MS21920-22

Purchased

No

Each

74.0000

4.0000

Clamp(per MIL-DTL-8783C)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

74

109495

6

110260

18

111210

50

10-129 5/

4

ml 10/01/20

December 1, 2009 12:42:24 PM

Shop Packet Print

Page 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

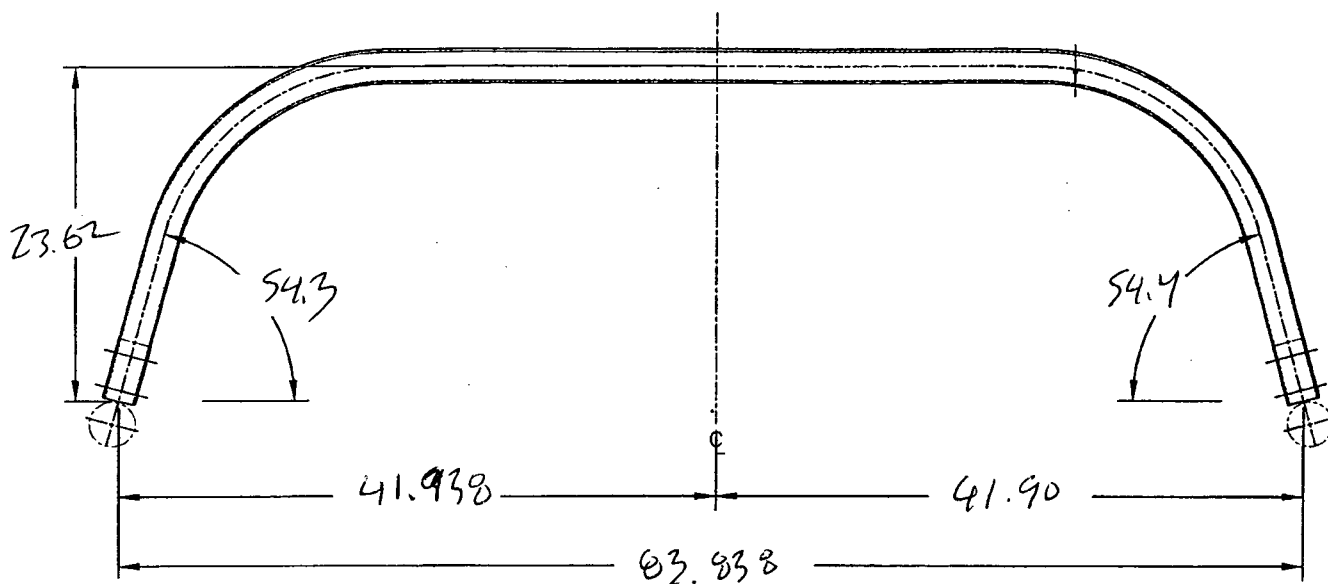
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|--|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 54146 |
| Description: Crosstube High Aft (206L) <i>07.12.07</i> | | Part Number: | D206-667-203 |
| Inspection Dwg: D206-667-243 Rev: <i>B C</i> | | Page 1 of 1 | |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 23.46 | 23.58 |
| 1/2 Span | 41.86 | 41.98 |
| Angle | 54 | 56 |
| Total Span | 83.72 | 83.96 |



| Comments |
|---|
| <i>Tube is bent high. Acceptable 07.12.07</i> |
| |
| |

| | |
|-----------------|--------------------|
| QC15 Inspection | <i>[Signature]</i> |
| Date | <i>07.12.08</i> |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|--------------------------|--------------------|
| A | 07.02.06 | New Issue | KJ/JM <i>[Signature]</i> | <i>[Signature]</i> |

| Item | Qty -243 | Part Number | Description |
|------|-------------|----------------|--|
| 1 | X | D206-667-243 | CROSSTUBE ASSEMBLY (206L HIGH AFT) |
| 2 | 1 | D6004-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2892-1 | SUPPORT |
| 6 | 4 | D3595-063-450 | RUBBER CUSHION |
| 7 | 4 | MS21920-22 | CLAMP |
| 8 | 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

STO
OF
EX
UNCOM
SUBC

WIDE

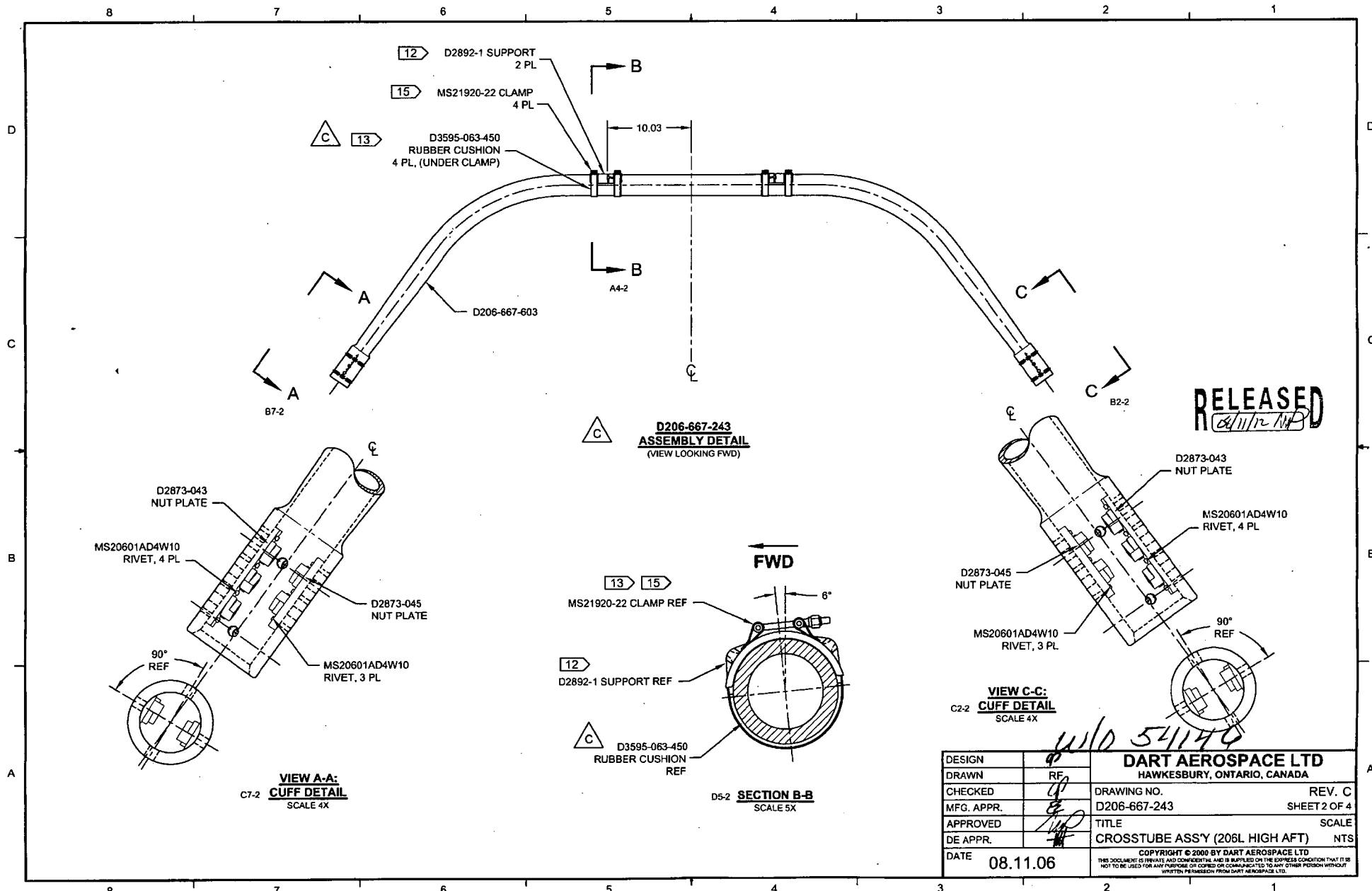
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NO. 541144

109-12-1

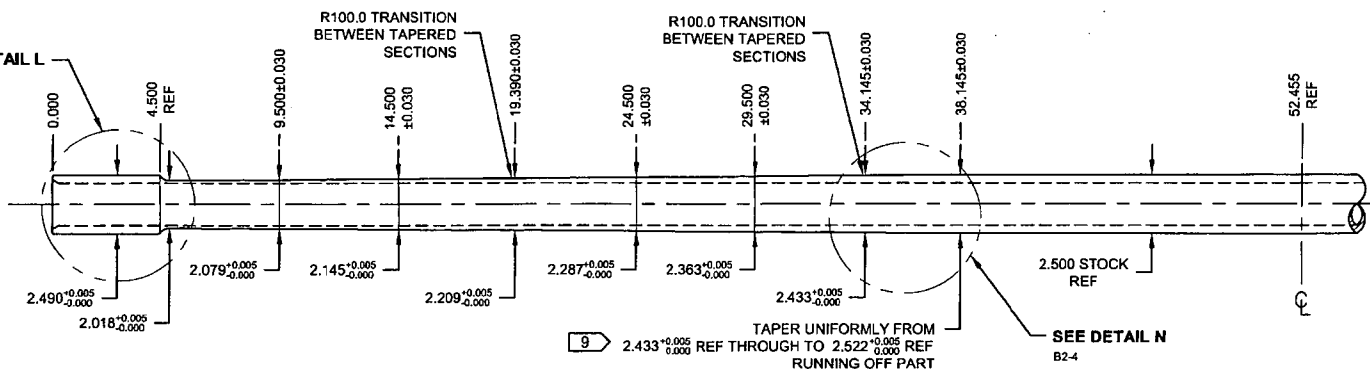
RELEASED
6/11/74

| | | | |
|------------|---|--|----------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 00.11.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 90 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. C D206-667-243 SHEET 1 OF 4 TITLE SCALE CROSSTUBE ASS'Y (206L HIGH AFT) NTS <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |
| DRAWN | RF | | |
| CHECKED | 10 | | |
| MFG. APPR. | 10 | | |
| APPROVED | 10 | | |
| DE APPR. | 10 | | |
| DATE | 08.11.06 | | |

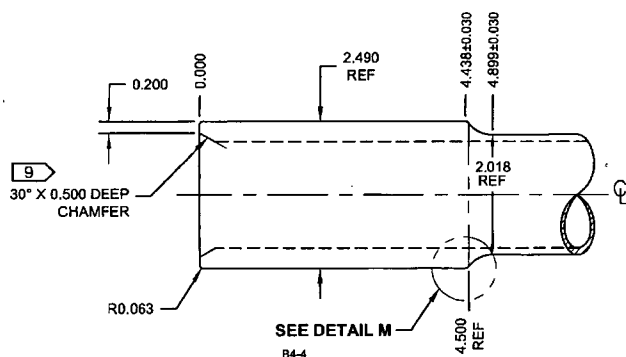


| | | | |
|------------|----------|--|--------------|
| DESIGN | REF | DART AEROSPACE LTD | |
| DRAWN | REF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | REF | DRAWING NO. | REV. C |
| MFG. APPR. | REF | D206-667-243 | SHEET 2 OF 4 |
| APPROVED | REF | TITLE | SCALE |
| DE APPR. | REF | CROSSTUBE ASS'Y (206L HIGH AFT) | NTS |
| DATE | 08.11.06 | <small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

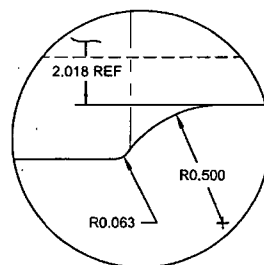
SEE DETAIL L
B7-4



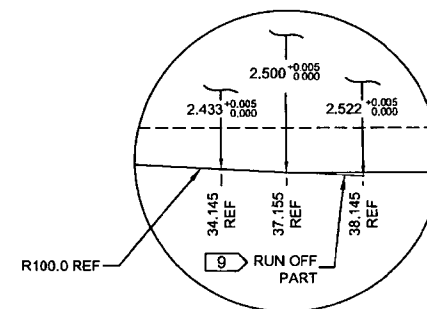
C TURNING DETAIL



C7-4 **DETAIL L: CROSSTUBE CUFF**
NOT TO SCALE



B6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

| | | | |
|------------|-----------|--|--------------|
| DESIGN | W/0 54146 | RELEASED 08/11/12 | |
| DRAWN | RF | | |
| CHECKED | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| MFG. APPR. | RF | | |
| APPROVED | RF | DRAWING NO. | REV. C |
| DE APPR. | RF | D206-667-243 | SHEET 4 OF 4 |
| DATE | 08.11.06 | TITLE | SCALE |
| | | CROSSTUBE ASS'Y (206L HIGH AFT) | NTS |

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REFERENCE ONLY

DART AEROSPACE LTD.

REFERENCE ONLY

IIN-D206-667

Page 14 of 14

REFERENCE ONLY

5.0 PARTS LIST

| Item | Qty -011 | Qty -013 | Qty -015 | Qty -101 | Qty -201 | Qty -103 | Qty -203 | Qty -105 | Qty -205 | Part Number | Description |
|------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|--|
| | X | | | | | | | | | D206-667-011 | SPACER BLOCK KIT |
| | | X | | | | | | | | D206-667-013 | NUT PLATE KIT (-101/-103/-105/-203/-205) |
| | | | X | | | | | | | D206-667-015 | NUT PLATE KIT (-201) |
| | | | | X | | | | | | D206-667-101 | CROSSTUBE INSTALLATION, 206A/B HIGH FWD |
| | | | | | X | | | | | D206-667-201 | CROSSTUBE INSTALLATION, 206A/B HIGH AFT |
| | | | | | | X | | | | D206-667-103 | CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD |
| | | | | | | | X | | | D206-667-203 | CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT |
| | | | | | | | | X | | D407-667-105 | CROSSTUBE INSTALLATION, 407 HIGH FWD |
| | | | | | | | | | X | D407-667-205 | CROSSTUBE INSTALLATION, 407 HIGH AFT |
| 1 | | | | 1 | | | | | | D206-667-141 | CROSSTUBE ASSEMBLY, 206A/B HIGH FWD |
| 2 | | | | | 1 | | | | | D206-667-241 | CROSSTUBE ASSEMBLY, 206A/B HIGH AFT |
| 3 | | | | | | 1 | | | | D206-667-143 | CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD |
| 4 | | | | | | | 1 | | | D206-667-243 | CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT |
| 5 | | | | | | | | 1 | | D407-667-145 | CROSSTUBE ASSEMBLY, 407 HIGH FWD |
| 6 | | | | | | | | | 1 | D407-667-245 | CROSSTUBE ASSEMBLY, 407 HIGH AFT |
| 10 | | | | *2 | *2 | *2 | | *2 | | D2891-1 | SUPPORT |
| 11 | | | | | | | *2 | | | D2892-1 | SUPPORT |
| 12 | | | | | | | | | *1 | D2894-1 | SUPPORT |
| 13 | | | | *2 | *2 | *2 | | *2 | | D2856-400-694 | ABRASION STRIP |
| 14 | | | | | | | *2 | | *2 | D2856-400-773 | ABRASION STRIP |
| 15 | | | | | | | | | *1 | D2856-600-851 | ABRASION STRIP |
| 16 | | | | *4 | *4 | *4 | | *4 | | MS21920-20 | CLAMP |
| 17 | | | | | | | *4 | | *4 | MS21920-22 | CLAMP |
| 18 | | | | | | | | | *2 | MS21920-24 | CLAMP |
| 19 | | | | 4 | 4 | 4 | | 4 | | AN5-32A | BOLT |
| 20 | | | | | | | 4 | | 4 | AN5-34A | BOLT |
| 21 | | | | 4 | 4 | 4 | 4 | 4 | 4 | MS21042L5 | NUT (OR MS21042-5) |
| 22 | | | | 8 | 8 | 8 | 8 | 8 | 8 | AN960JD516 | WASHER |
| 23 | | | | | | | | | *2 | D3190-1 | CHAFING SHIELD |
| 30 | 8 | | | | | | | | | AN4-6A | BOLT |
| 31 | 8 | | | | | | | | | AN4-7A | BOLT |
| 32 | 16 | | | | | | | | | AN960JD416 | WASHER |
| 33 | 2 | | | | | | | | | D3193-041 | SPACER BLOCK ASSEMBLY |
| 40 | | 2 | | *2 | | *2 | *2 | *2 | *2 | D2873-043 | NUT PLATE |
| 41 | | 2 | | *2 | | *2 | *2 | *2 | *2 | D2873-045 | NUT PLATE |
| 42 | | | 2 | | 2 | | | | | D2872-043 | NUT PLATE |
| 43 | | | 2 | | 2 | | | | | D2872-045 | NUT PLATE |
| 44 | | 10 | | 10 | | 10 | | | | AN5-7A | BOLT |
| 45 | | 10 | 10 | | 10 | | 10 | 10 | 10 | AN5-10A | BOLT |
| 46 | | 4 | 4 | 4 | 10 | 4 | | 4 | | AN5-30A | BOLT |
| 47 | | 4 | | | | | 4 | | 4 | AN5-32A | BOLT |
| 48 | | 18 | 18 | 10 | 12 | 10 | | 10 | 10 | AN960JD516 | WASHER |
| 49 | | 4 | 4 | | 6 | | | | | MS21042L5 | NUT (OR MS21042-5) |

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

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Revision: C

Date: 05.07.26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 15313

| | | | | | | | | |
|------------------|---|-----------------|---------------|---------------|-------|-------------------------------------|----|--------------------------|
| CLIENT | DATAEROSPACE | DATE | DEC 12-2007 | PAGE | 1 | OF | 1 | |
| ATTENTION | LINDA/CRANTZ | ACUREN JOB NO. | 188-09-001649 | TIME | AM | <input checked="" type="checkbox"/> | PM | <input type="checkbox"/> |
| ADDRESS | 1270 ABELSEEN ST. HAWKES BURY, ON, K6H 1K7 | PO/NO No. | - 10943 | WORK LOCATION | SAN.E | | | |
| PROJECT | F.P.I. ON THREE CROSS TUBES | ACCEPTANCE STD. | ASTM 1417 | REV./DATE | 2007 | | | |
| ITEM(S) EXAMINED | | | | | | | | |

| | | |
|-----------------|--|-------------------------------------|
| JOB DESCRIPTION | PROCEDURE NO. LT-002 REV./DATE 2007 | TECHNIQUE NO. LT-002 REV./DATE 2007 |
| PART NO. | MATERIAL ALUMINUM THICKNESS | |
| SCOPE | WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL | |

| | |
|--|--|
| TEST DETAILS | |
| METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE | <input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED |
| FAMILY BRAND MAX GNA-FLUX | BLACK LIGHT S/N 16459 <input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc |
| PENETRANT ZLG7 MINIMUM DWELL TIME 45 MIN. | LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE |
| PENETRANT REMOVER H2O MINIMUM DRY TIME > 10 MIN. | OTHER LABINO |
| DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. | LIGHT METER S/N 1098866 CAL DUE DATE 10-1-23 |
| DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY | |

| | |
|--|--|
| TEST SURFACE | |
| SURFACE CONDITION <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL | |
| SURFACE TEMPERATURE <input type="checkbox"/> < - 4°C/ 20°F <input type="checkbox"/> - 4°C/ 20°F TO 10°C/ 50°F <input checked="" type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F <input type="checkbox"/> > 52°C/ 125°F | |

RESULTS- (☐ METRIC ☐ IMPERIAL)

1 Crosstube W.O. 54146 ✓
1 Crosstube - W.O. 54215 ✓
1 Crosstube - W.O. 54211 ✓

THESE ITEMS FOUND
ACCEPTABLE TO CODE.

MM 09 12 15

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

| | | |
|-------------------------------------|----------------------------|---------------|
| SIGNATURES | | DTR # E-27685 |
| CLIENT REPRESENTATIVE Jason Murdoch | SIGNATURE | REPORT |
| TECHNICIAN (SIGNATURE): | | REVIEWED BY: |
| NAME (PRINT): Mike Johnston | 2 nd TECHNICIAN | NAME INITIALS |
| CGSB LEVEL I SNT LEVEL II | CGSB LEVEL SNT LEVEL | |
| CGSB REG. NO. 00660 | CGSB REG. NO. | |